

Date: Monday, 12/01/2009 10:16:09 AM
 User: Julie Dawson

Process Sheet

ASAP

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PANEL
 Job Number : 44639
 Estimate Number : 10905
 P.O. Number :
 This Issue : 12/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 44239
 Part Number : D33302
 Drawing Number : D3330 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 19/01/2009 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : JLD 09.01.12
 Comment : Est. A 05.01.13 New issue KJ/JLM
 Est Rev:B Now on Waterjet 06-09-25 JLM
 est C 07.05.14 rev C dwg EC
 Est D 07.12.12 Rev D dwg EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S125 1010-1025 sheet .125



Comment: Qty.: 1.1445 sf/s/Unit Total : 6.8670 sf/s

1010-1025 sheet .125

Batch: 109947 HB 9-2-3

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3330

Dwg Rev: D HB 9-2-3

Prog Rev: D

2-Deburr if necessary HB 9-2-3

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK S 09/02/03 HB 9-2-3

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D3330 S 09/02/03 HB 9-2-3

Date: Monday, 12/01/2009 10:16:09 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 44639

Part Number: D33302

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/02/24 (x3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WK

u 09.02.25

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/25

Job Completion

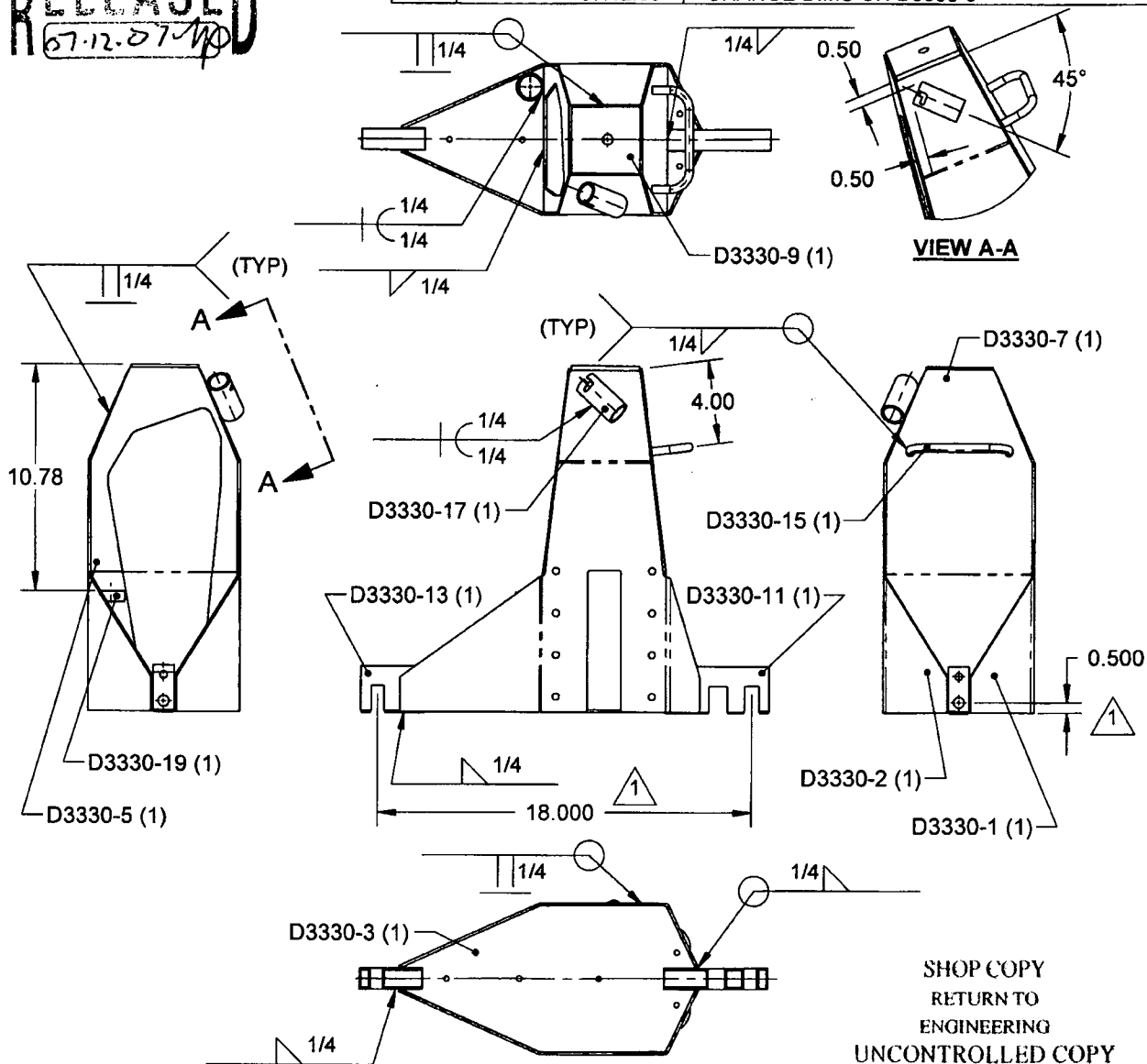


u 09.02.25



DESIGN 13	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED [Signature]	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

RELEASED
07-12-07



D3330-041 FRAME WELDMENT

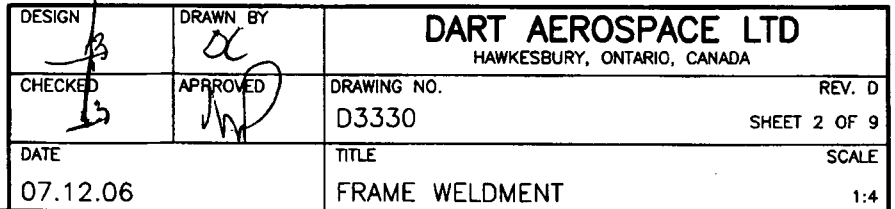
NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

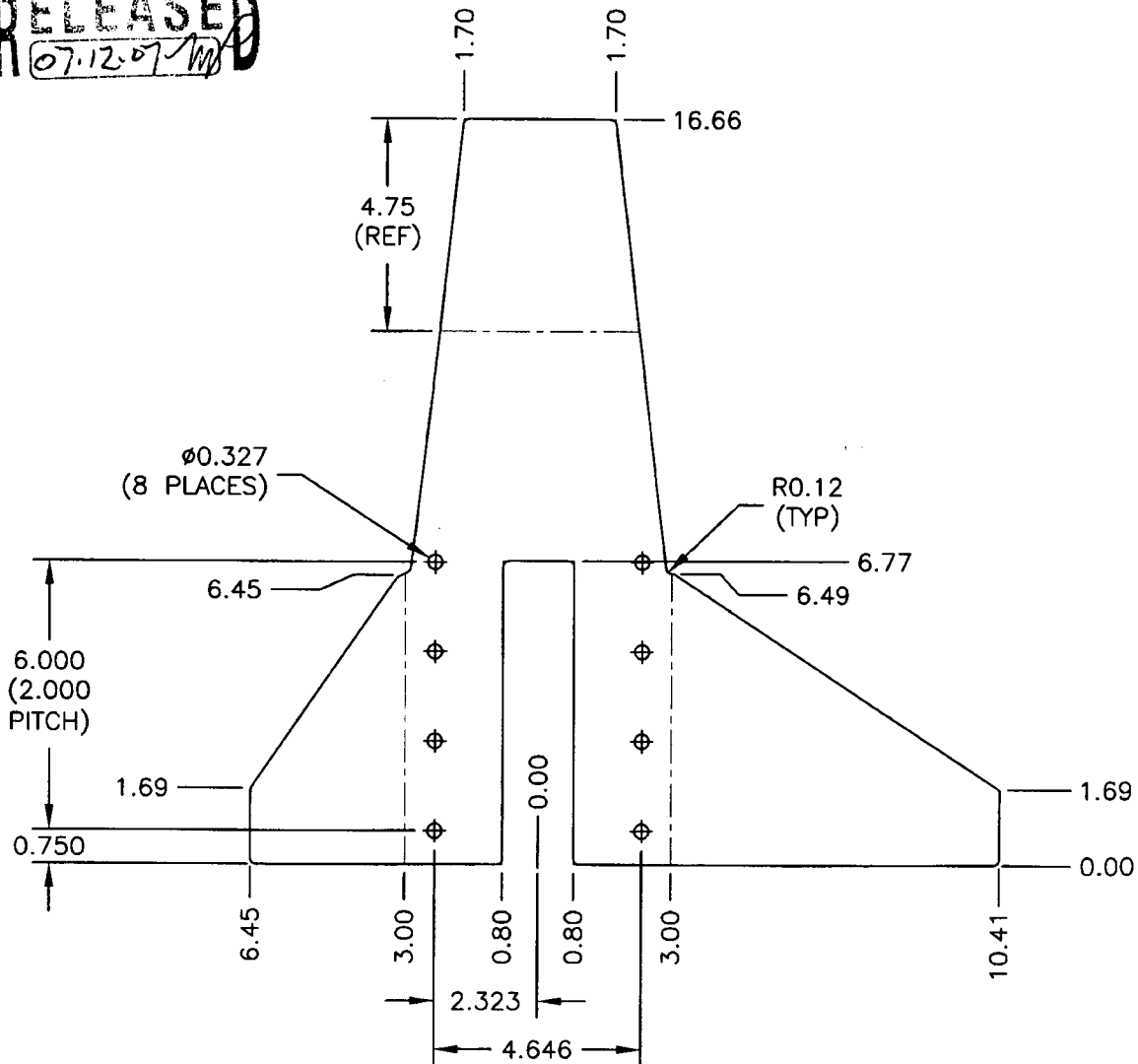
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07.12.07



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38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

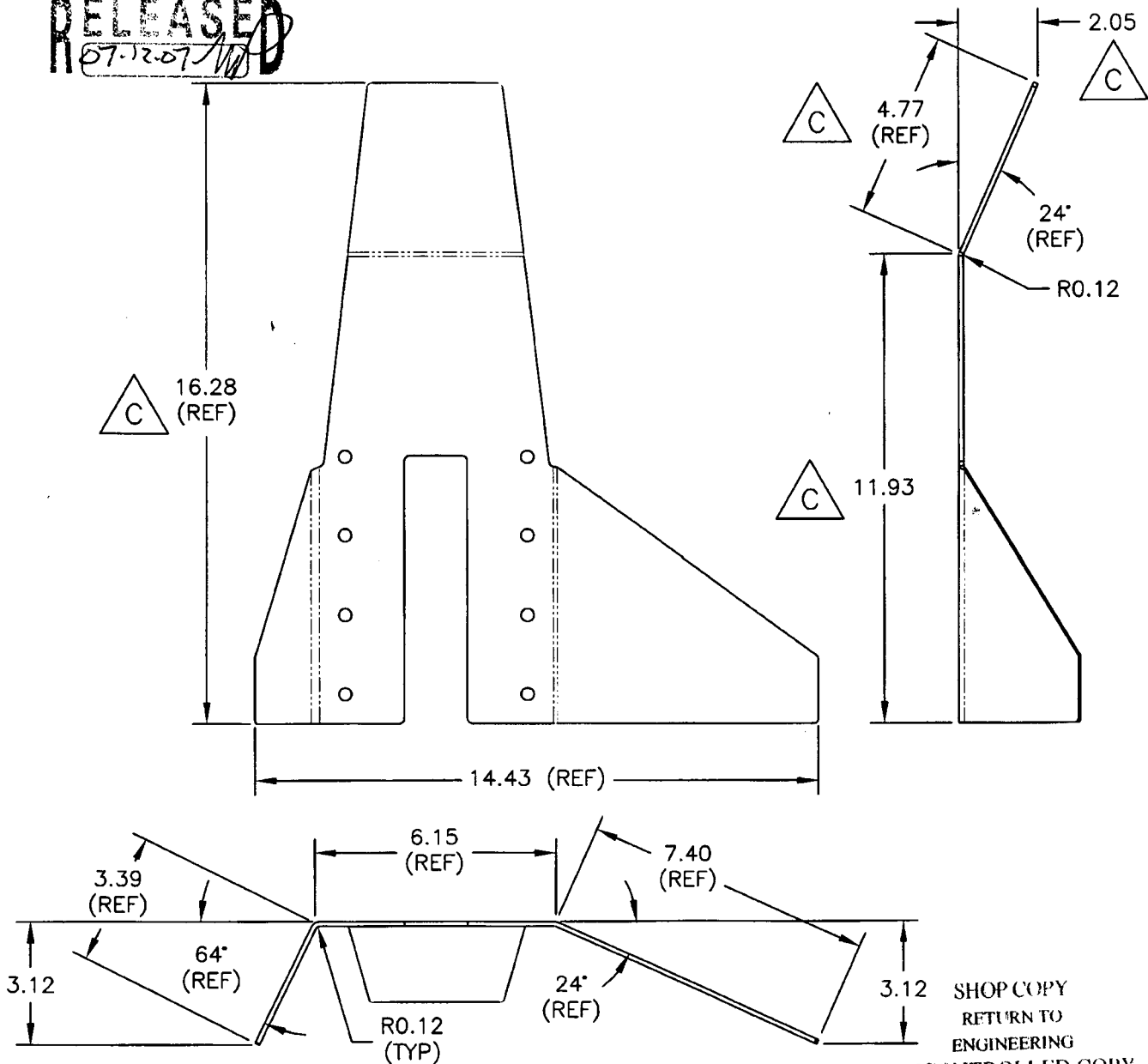
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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07-12-07



D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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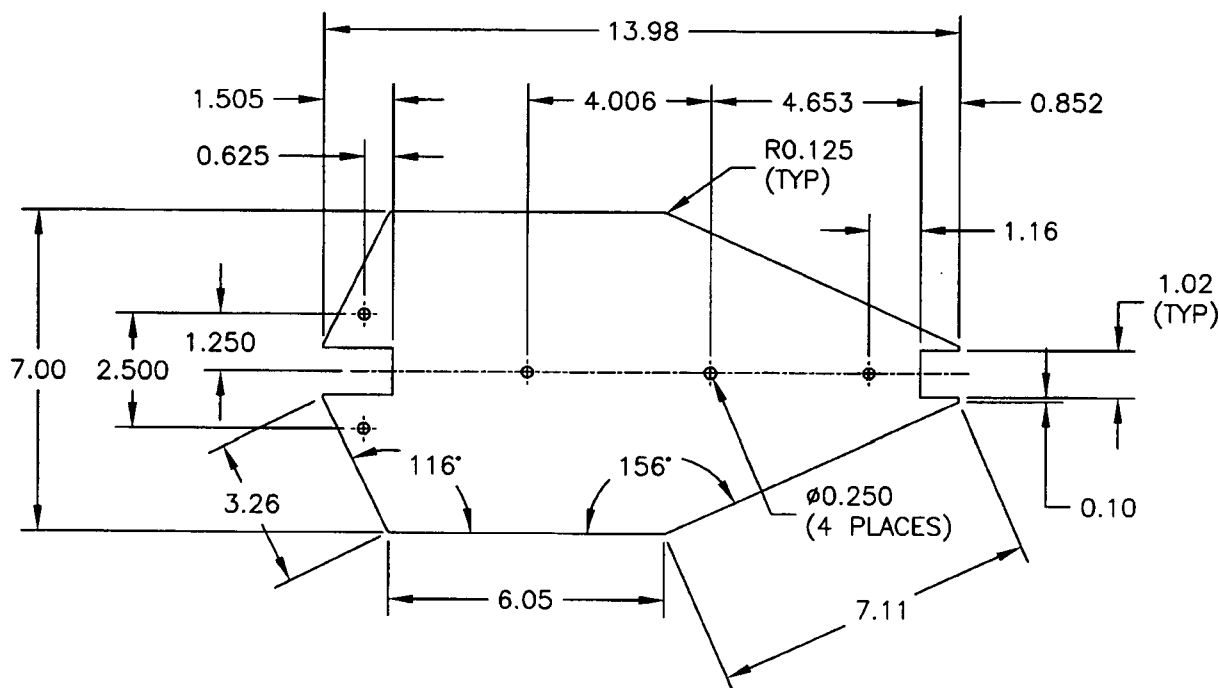
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D3330-3 PLATE

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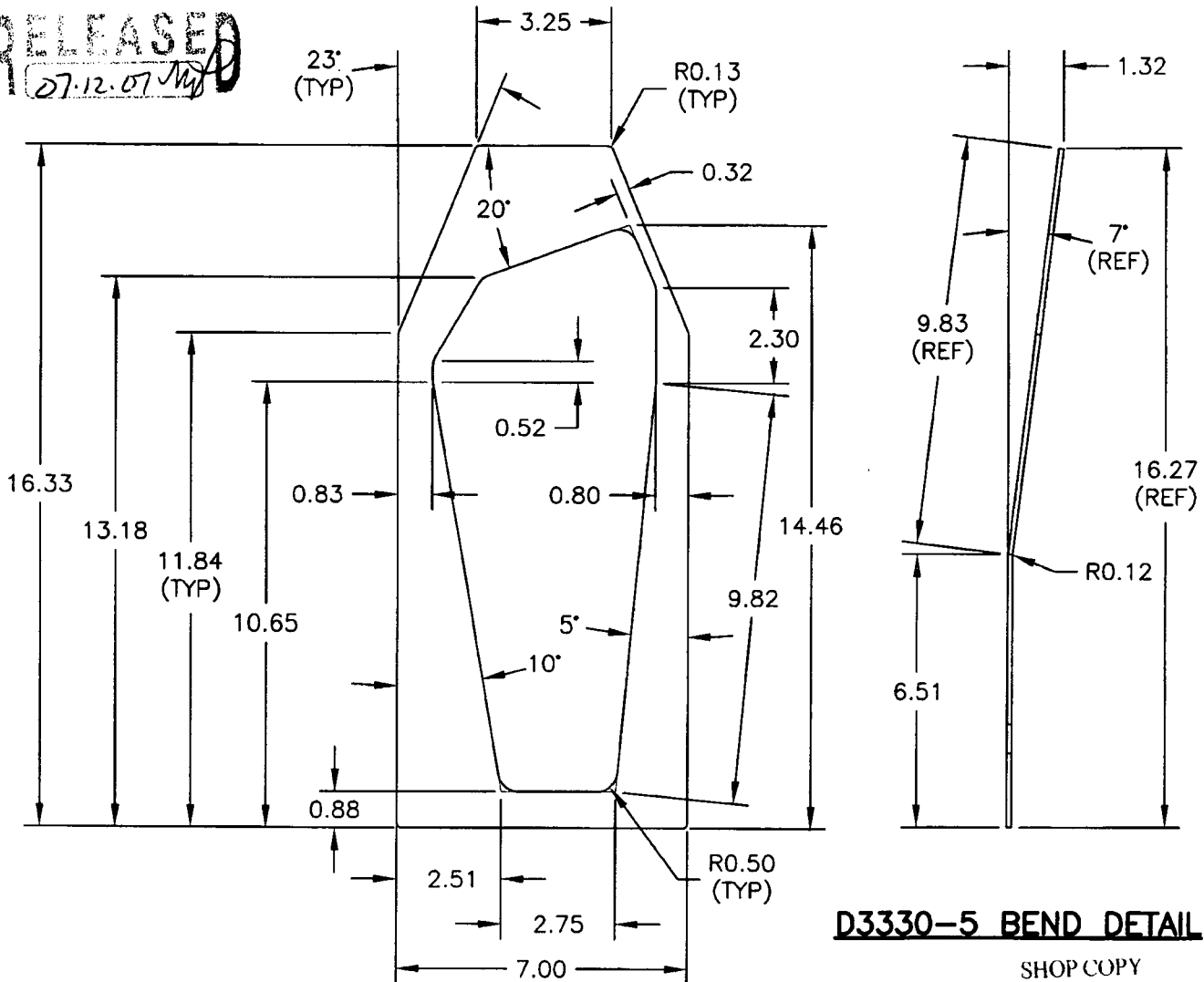
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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RELEASED
27.12.07 *MD***FLAT PATTERN****D3330-5 BEND DETAIL**

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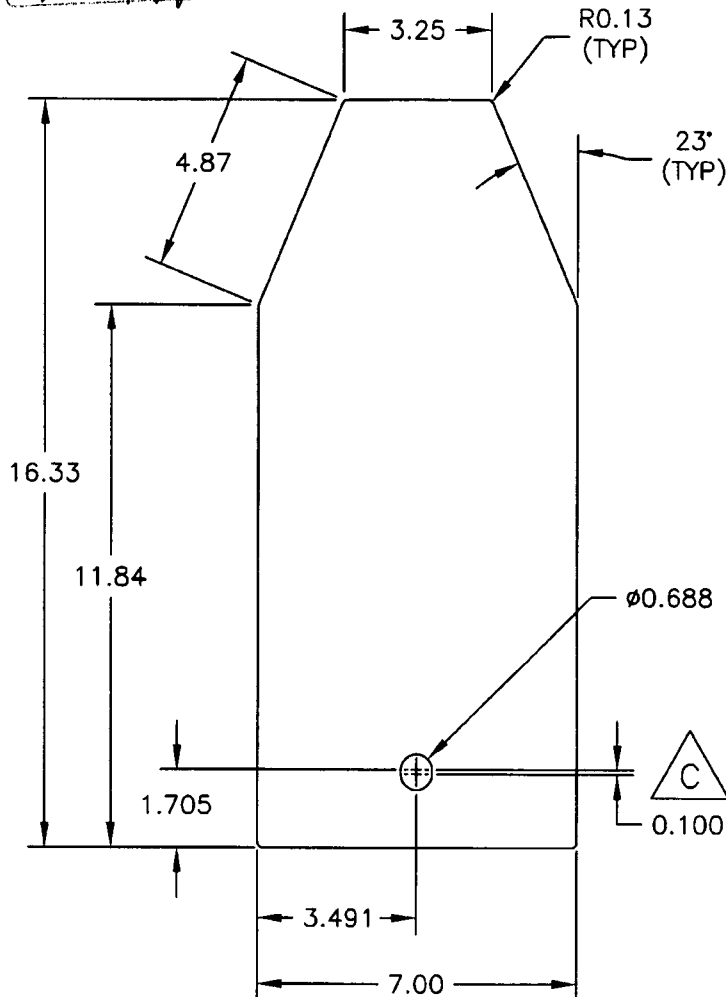
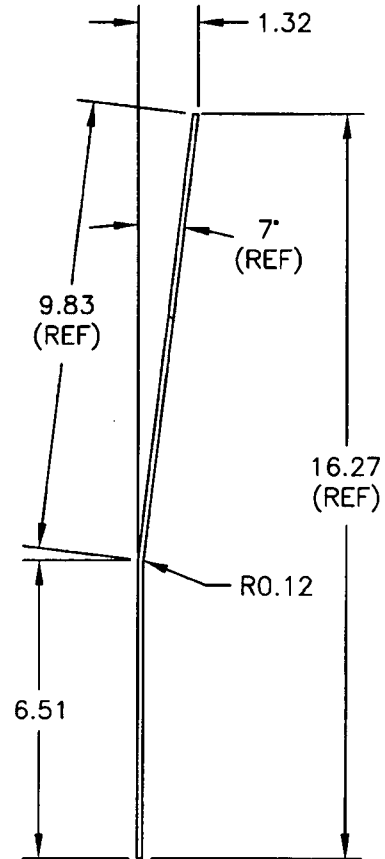
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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07.12.07 *[Signature]***FLAT PATTERN****D3330-7 BEND DETAIL**

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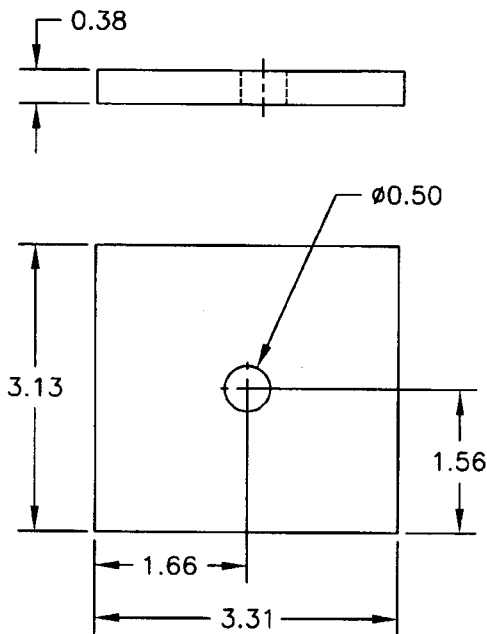
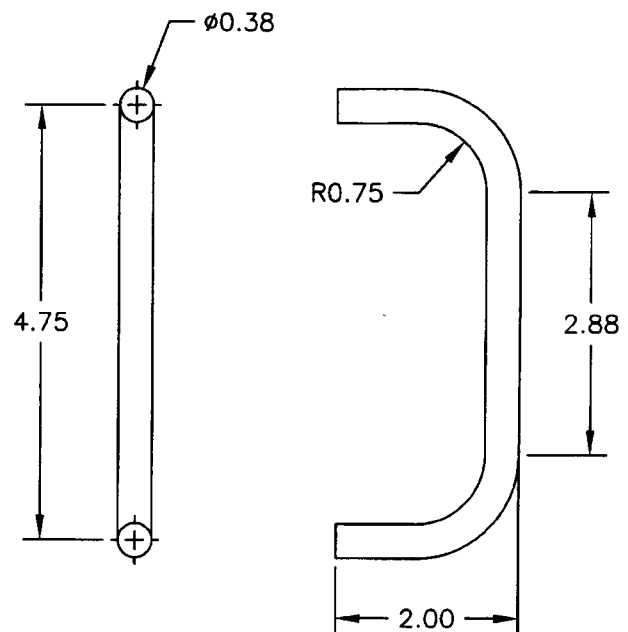
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- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

RELEASED
07.12.07**1 D3330-9 TOP PLATE****2 D3330-15 HANDLE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL (REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

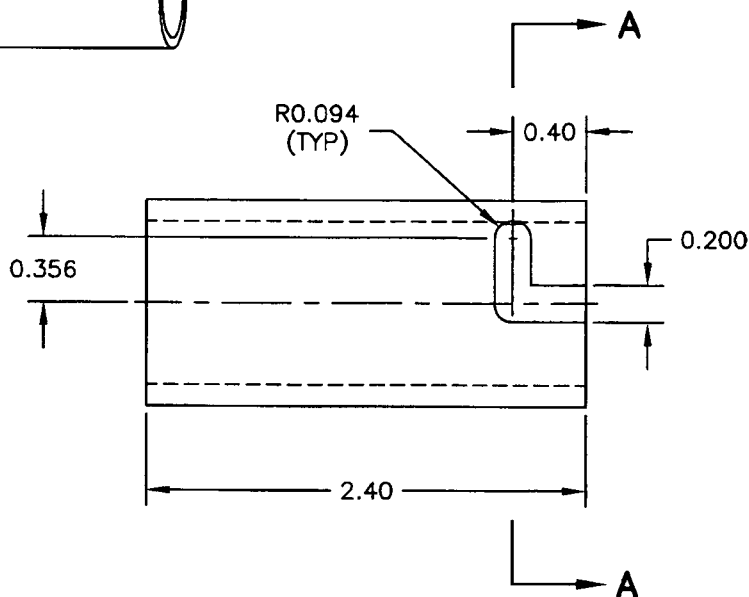
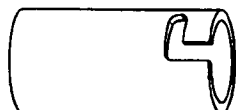
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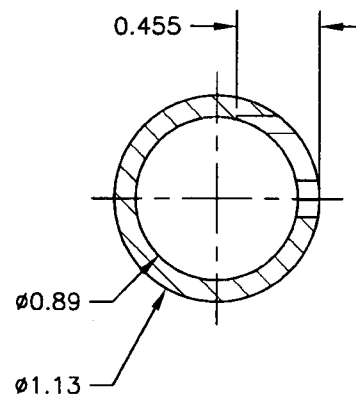
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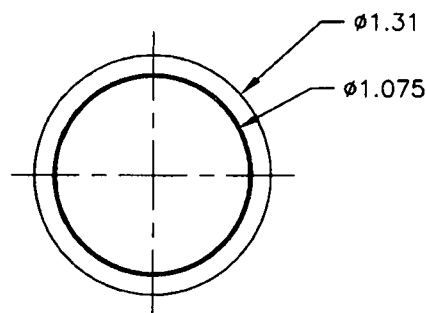
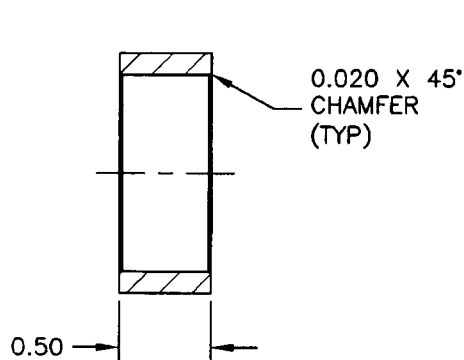


RELEASED
07.12.07 *[Signature]*



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

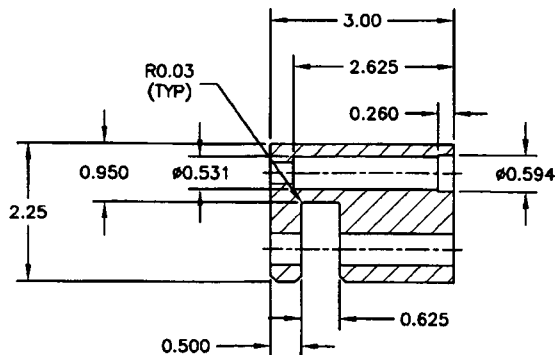
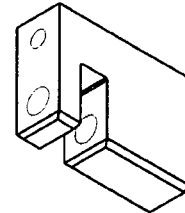
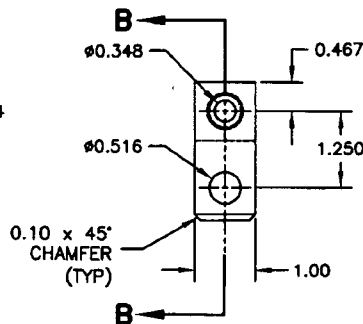
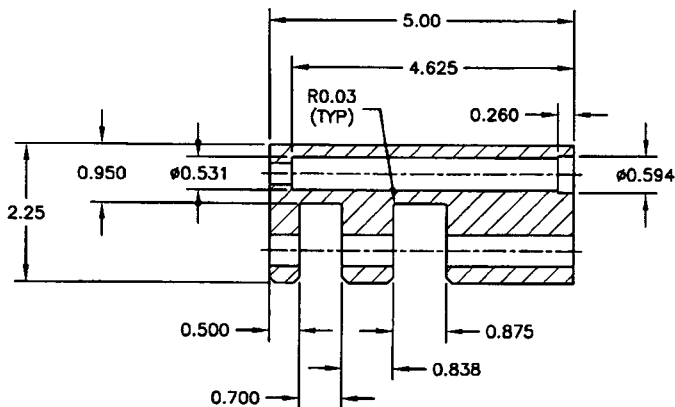
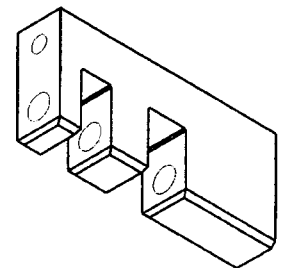
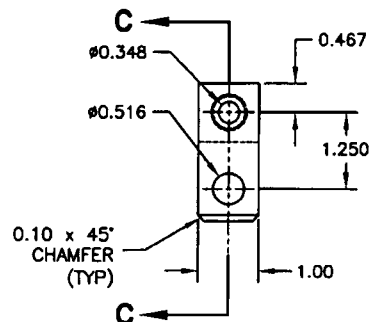
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

**SECTION B-B****D3330-13 SHORT PIN BRACKET****RELEASED**
07.12.07 *[Signature]***SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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